

**\*89585\***

Monday, August 27, 2012 7:47:38 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**\*4\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

|                              |   |      |    |          |   |   |
|------------------------------|---|------|----|----------|---|---|
| 100                          | BAND SAW  | 0.00 |    |          |   |   |
| <b>*100*</b>                 |   |      |    |          |   |   |
| Bandsaw                      | <b>Memo</b>   | 0.00 | PO | 12/08/27 | 4 | Ø |
| Jeaspa Bandsaw               | Cut blanks: 1.000" x 0.375" x 2.700" long   |      |    |          |   |   |
| 110                          | HAAS CNC VERTICAL MACHINING #1  | 0.00 |    |          |   |   |
| <b>*110*</b>                 |   |      |    |          |   |   |
| HAAS 1                       | <b>Memo</b>   | 0.00 |    |          |   |   |
| HAAS CNC vertical machine #1 | Machine as per Folio FA and Dwg D28731 identify as D2873-5<br>Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u> |      | PO | 12/08/27 | 4 | Ø |
| 120                          | QC2- Inspect parts off machine FAI/FAIB   | 0.00 |    |          |   |   |
| <b>*120*</b>                 |   |      |    |          |   |   |
| QC                           | <b>Memo</b>   | 0.00 | PO | 12/08/27 | 4 | Ø |
| Quality Control              |   |      |    |          |   |   |



**Work Order ID 89585**

Monday, August 27, 2012 7:47:38 AM

**\*89585\***

Page 2

Item ID: D2873-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Nut Plate Assembly  
Start Date: 8/27/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 8/30/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | QC8- Inspect parts - second check             | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 140                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   | Small Fab                                     |                      |         |        |              |               |               |                  |                |
| Small Fab                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                      | 1-Deburr 2- C'sink as per Dwg D2873           |                      |         |        |              |               |               |                  |                |
| 150                            | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

*Handwritten:* J.A. 12.08.27

*Handwritten:* 4/12/08/27

*Handwritten:* 4

*Handwritten:* 12/08/27



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1-Assemble as per Dwg D2873    2-Identify as D2873-045



**Work Order ID 89585**

Monday, August 27, 2012 7:47:38 AM

**\*89585\***

Page 4

Item ID: D2873-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Nut Plate Assembly

Start Date: 8/27/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 8/30/2012 Req'd Qty: 4.00

**\*4\***

Customer:

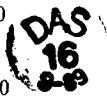



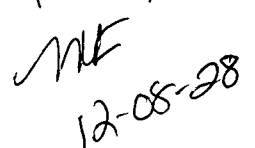
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                      | Set Up/<br>Run Hours   | Tool ID | Tool #   | Plan<br>Code | Accept<br>Qty   | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp  |
|---|---|--|---------|----------|--------------|---|---------------|------------------|---|
| 190<br><b>*190*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo     | 0.00<br><br>0.00 |         | 12/08/27 |              |    |               |                  |   |
| 200<br><b>*200*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <b>LG52</b><br><br>Memo | 0.00<br><br>0.00   |         |          |              |   | 12-8-27       |                  |   |
| 210<br><b>*210*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo       | 0.00<br><br>0.00   |         |          |              |  | 12/8/28       |                  |  |





# Picklist Print

Monday, August 27, 2012 7:47:37 AM

Page 1

Work Order ID: 89585

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 8/27/2012

Required Date: 8/30/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.09.13New issueKJ/JLM

| Component Item ID/<br>Item Name                | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.375X01.000<br>6061T6 BAR .375 x 1.00 |                        | Purchased     | No          |                     |                  | 180             | f                  | 24.3760        | 0.225       | 0.9473684    |               |                |        |

Location Loc Qty Loc Code

MAT001 2.292  
118641 2.292  
MAT002 22.084  
120603 0.76  
120866 0.76  
121192 0.046  
→ 121836 20.518

PD 12/08/27

MS20426AD4-6

Rivet

Purchased

No

180 Each 1,256.8870

4 16

Location Loc Qty Loc Code

ST317 1255  
110139 187  
118510 13  
119436 85  
121708 970  
ST334 1.887  
122814 1.887

0.95  
16  
12/08/27

MS21075L5

Nut Plate

Purchased

No

100 Each 206.0000

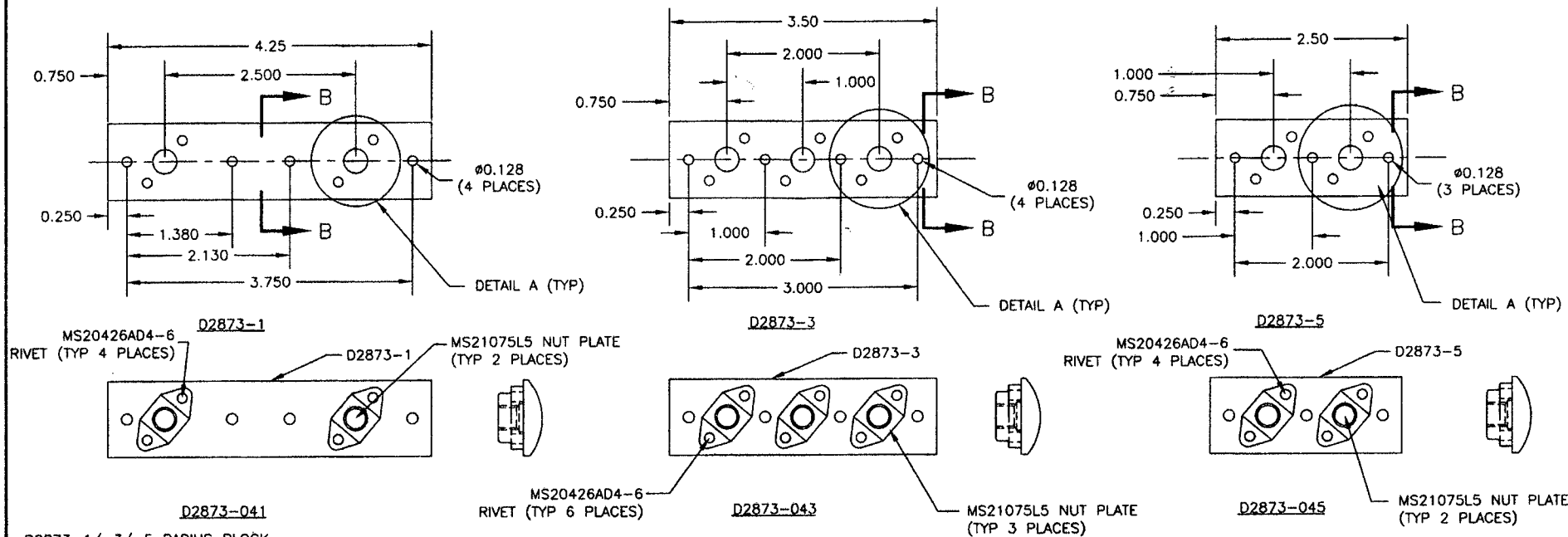
2 8

Location Loc Qty Loc Code

ST321 206  
121827 206

16  
8  
12/08/27





#### D2873-1/-3/-5 RADIUS BLOCK

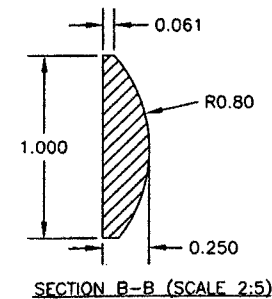
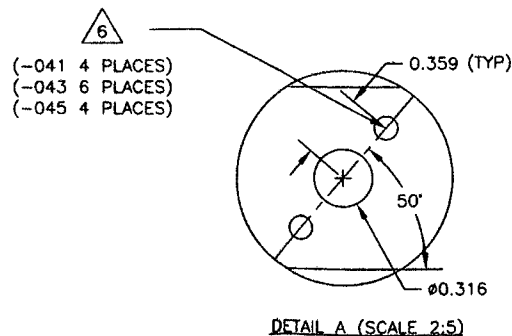
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.125$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100$

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

| -041 | -043 | -045 | PART NUMBER  | DESCRIPTION        |
|------|------|------|--------------|--------------------|
| X    |      |      | D2873-041    | NUT PLATE ASSEMBLY |
|      | X    |      | D2873-043    | NUT PLATE ASSEMBLY |
|      |      | X    | D2873-045    | NUT PLATE ASSEMBLY |
| 1    |      |      | D2873-1      | RADIUS BLOCK       |
|      | 1    |      | D2873-3      | RADIUS BLOCK       |
|      |      | 1    | D2873-5      | RADIUS BLOCK       |
| 4    | 6    | 4    | MS20426AD4-6 | RIVET              |
| 2    | 3    | 2    | MS21075L5    | NUT PLATE          |



RELEASED  
(05-07-26)

|            |             |  |
|------------|-------------|--|
| A          | 05.07.26    | NEW ISSUE  |
| DESIGN     | PH          | DRAWN BY PH  |
| CHECKED DS | APPROVED DS | DART DART AEROSPACE LTD<br>WILLOWDALE, ONTARIO, CANADA |
| DATE       | 05.07.26    | DRAWING NO. D2873                                      |
|            |             | TITLE RADIUS BLOCK                                     |
|            |             | REV. A SHEET 1 OF 1 SCALE 4:5                          |

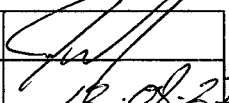




|  |  |                     |         |
|--|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                  |  | <b>Work Order:</b>  |         |
| <b>Description:</b> Radius Block           |  | <b>Part Number:</b> | D2873-5 |
| <b>Inspection Dwg:</b> D2873 <b>Rev:</b> A |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Drawing Dimension | Tolerance             | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------------|------------------|--------|--------|----------------------|----------|
| 2.50              | +/-0.030              | 2.500            | ✓      |        | VERN                 | P40-01   |
| 1.000             | +/-0.010              | 1.000            | ✓      |        | "                    | "        |
| 0.750             | +/-0.010              | 0.749            | ✓      |        | "                    | "        |
| 0.250             | +/-0.010              | 0.249            | ✓      |        | "                    | "        |
| 1.000             | +/-0.010              | 1.000            | ✓      |        | "                    | "        |
| 2.000             | +/-0.010              | 2.000            | ✓      |        | "                    | "        |
| Ø0.128            | +0.005/-0.001         | 0.129            | ✓      |        | "                    | "        |
| 0.359             | +/-0.010              | 0.359            | ✓      |        | "                    | "        |
| Ø0.316            | +0.006/-0.001         | 0.317            | ✓      |        | "                    | "        |
| 1.000             | +/-0.010              | 1.004            | ✓      |        | "                    | "        |
| 0.250             | +/-0.010              | 0.244            | ✓      |        | "                    | "        |
| 0.061             | +/-0.010              | 0.060            | ✓      |        | "                    | "        |
| Ø0.230 x 0.125    | +0.005/-0.001 x 0.010 | 0.230 x 0.118    | ✓      |        | "                    | "        |
|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |
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|                   |                       |                  |        |        |                      |          |
|                   |                       |                  |        |        |                      |          |

|                        |  |                            |     |
|------------------------|--|----------------------------|-----|
| <b>Measured by:</b> PO | <b>Audited by:</b>  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 12/08/27  | <b>Date:</b> 12.08.27  | <b>Date:</b>               | N/A |

| Rev | Date     | Change                       | Revised by   | Approved  |
|-----|----------|------------------------------|--|---|
| A   | 06.08.30 | New Issue      P/O D2873-045 | KJ/JLM  |  |

